

Work Order ID 56873

March 11, 2010 1:39:32 PM



Page 1

Item ID: D2565-203

Accept

Revision ID:

Item Name: Strut

Start Date: 11/03/2010 Start Qty: 3.00

Required Date: 16/03/2010 Req'd Qty: 3.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-3-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100



Brake NC

Brake NC

NC BRAKE

Memo

Punch as per Dwg D2565 using DT 8313

0.00

0.00

SB 10/03/11

③

110



Small Fab

Small Fab

Small Fab

Memo

Drill hole as per Dwg D2565 (one end only)

☐ Debur

0.00

0.00

SB 10/03/11 ③

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Scotter/11/11

④

⑤

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565-203 PAR #: _____ Fault Category: Small fab. NCR: Yes No DQA: Yes Date: 10/03/29
 Resolution: re-work Disposition: re-work QA: N/C Closed: Yes Date: 10/03/30

NCR: <u>56873</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/17	#100	Found @ inspection that two struts are too long Dim A is 20.875" + Dim B is 20.06". Parts were moved	<u>[Signature]</u>	Good for D2565-307 but holes was drilled out for .316" Identifying with original mat. Batch number and use for A	<u>[Signature]</u> 10/03/18	<u>[Signature]</u> 10/03/18	<u>[Signature]</u>	<u>[Signature]</u> 10/03/17
		Rt. employee mixed up the Dwg. & Parts were originally left oners (from used parts) RC: Lack of attention	<u>[Signature]</u>	shorten strut. No Replace. Qty x2	<u>[Signature]</u> 10/03/18	<u>[Signature]</u> 10/03/18	<u>[Signature]</u>	<u>[Signature]</u> 10/03/17

NOTE: Date & initial all entries

Work Order ID 56873

March 11, 2010 1:39:32 PM



Page 2

Item ID: D2565-203

Revision ID:

Item Name: Strut

Start Date: 11/03/2010 Start Qty: 3.00

Required Date: 16/03/2010 Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

START TIME:

12:00pm FINISH TIME:

11:30am

OVEN TEMPERATURE:

400°F

0.00

=> All 10/03/8



Ø

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

50 lbs



150



Packaging

Packaging

Identify as per dwg & Stock Location: 270

0.00

Memo

0.00

10/03/22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56873

March 11, 2010 1:39:32 PM



Page 3

Item ID: D2565-203

Revision ID:

Item Name: Strut

Start Date: 11/03/2010 Start Qty: 3.00

Required Date: 16/03/2010 Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

10/03/24

PL 10-3-22
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 11, 2010 1:39:37 PM

Page 1

Work Order ID: 56873

Parent Item: D2565-203

Parent Item Name: Strut

Comments: IPP: D01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC

Start Date: 11/03/2010

Required Date: 16/03/2010

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	121.3206	5.5263			
304 RD Tube .750 x .049W												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	121.3206	
107518	2.77	
108498	0	
109314	8.5	
110113	0.73	
110271	0.03	
111096	9	
111457	11.43	
112652	20.34882	
112800	68.51178	

2.333
80 12/03/10 ③

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

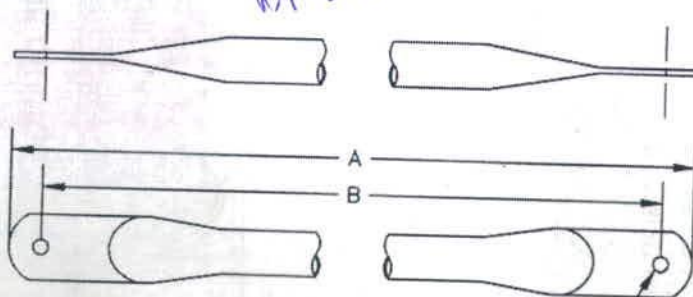
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 56873

04-10-3-11

DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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